












Date: Tuesday, 07/10/2008 10:16:43 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LEFT ARM WELDMENT
Job Number	: 42497		
Estimate Number	: 11876		
P.O. Number	:	Part Number	: D33547
This Issue	: 07/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3354 REV C
First Issue	: / /	Project Number	: N/A
Previous Run	: 36233	Drawing Revision	: C
Written By	:	Material	:
Checked & Approved By	: <u>JUL 08 10.07</u>	Due Date	: 30/10/2008
Comment	: est rev. A 06.01.14 new issue EC est rev B 07.03.23 revB dwg EC Est Rev:C 07-12-10 rev C dwg DD verified by:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M1010B1000X02000	1010-1025 Steel Bar 1.00 x 2.00	
			
Comment: Qty.: 0.5597 f(s)/Unit Total : 5.5965 f(s) 1010-1025 BAR AISI 1010-1025 Steel bar 2.00" x 1.00" Batch: <u>M107436 ml 08/10/11</u> 10			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut blanks 6.100" long <u>ml 08/10/11</u> 10			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA611 and Dwg D3353 2- Deburr <u>ml 08/10/12</u> 10			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 08/10/12</u> 10			
5.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>SP 08/10/14</u> (10)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/10/2008 10:16:43 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEFT ARM WELDMENT

Job Number: 42497

Part Number: D33547

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

8/10/14

(10x)

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/15

Job Completion



MF 08-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40497
Description: Left Arm Plate		Part Number: D3354-7
Inspection Dwg: D3354	Rev: PC <i>PC</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.35	+/-0.030	5.350	✓			
1.150	+/-0.010	1.147	✓			
2.500	+/-0.010	2.499	✓			
1.487	+/-0.010	1.487	✓			
0.200	+/-0.010	200	✓			
0.800	+/-0.010	790	✓			
1.000	+/-0.010	993	✓			
2.00	+/-0.030	1.996	✓			
0.375	+/-0.010	370	✓			
0.500	+/-0.010	500	✓			
Ø1.251	+0.005/-0.000	Ø1.256	✓			
Ø0.250	+0.005/-0.001	Ø.250	✓			
Ø1.000	+0.015/-0.000	Ø1.006	✓			
Ø0.406	+0.006/-0.001	Ø.411	✓			
6.00	+/-0.030	5.990	✓			
1.00	+/-0.030	.992	✓			

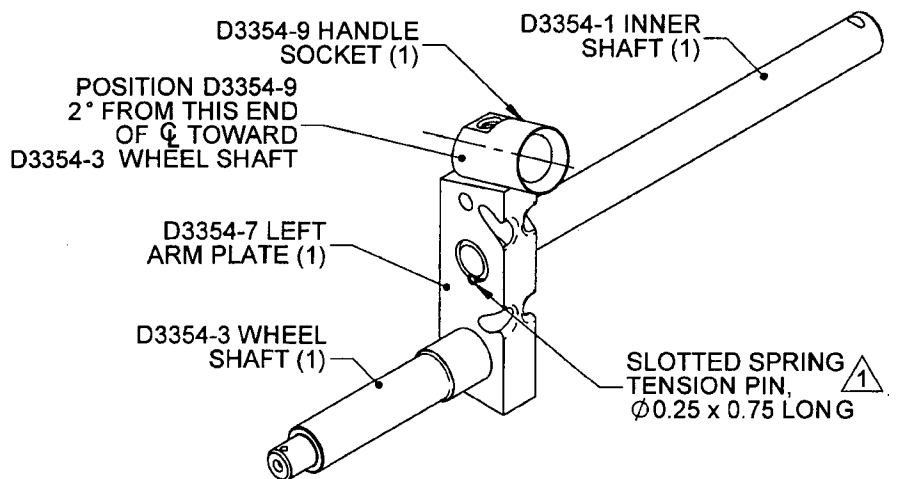
Measured by: <i>mf</i>	Audited by: <i>JS</i>	Prototype Approval:	N/A
Date: 08/10/12	Date: 08/10/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.12.10	New Issue	KJ/EC/DD <i>JS</i>	<i>JS</i>

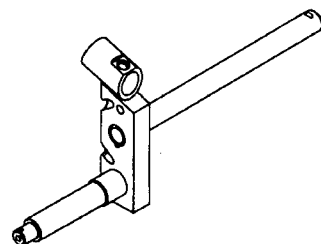


DESIGN <i>RF</i>	DRAWN BY <i>JC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LB</i>	APPROVED <i>WJ</i>	DRAWING NO. LEFT ARM WELDMENT	REV. C SHEET 1 OF 7
DATE 07.12.06		TITLE D3354	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	
C	07.12.06	CHANGE TOLERANCE ON D3354-7 LEFT ARM PLATE HOLE FOR D3354-3 WHEEL SHAFT	

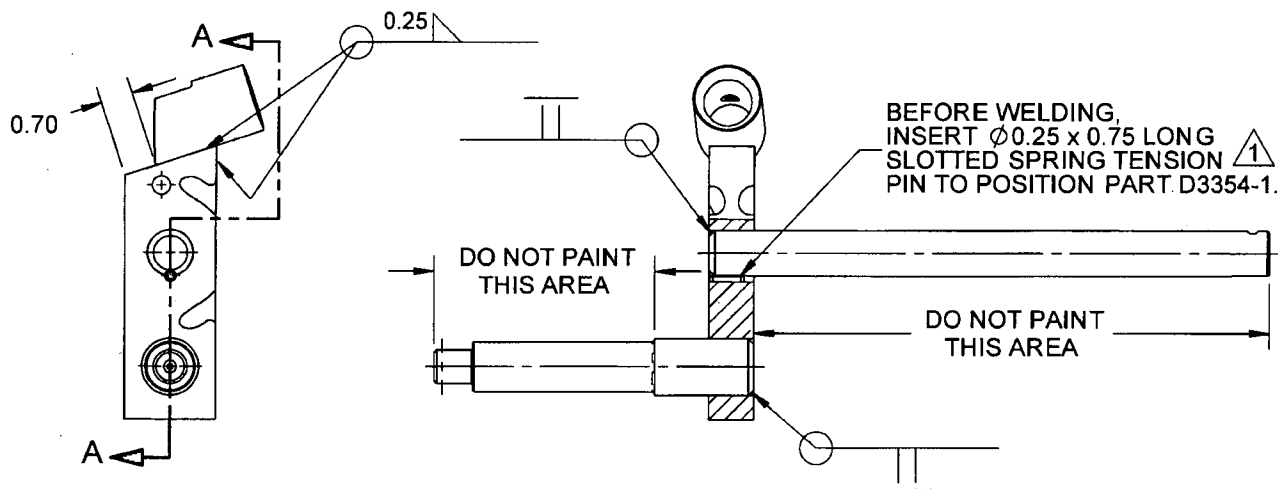
RELEASED
07/12/07 *WJ*



D3354-041 LEFT ARM WELDMENT



D3354-042 MIRROR ARM WELDMENT



SECTION A-A

NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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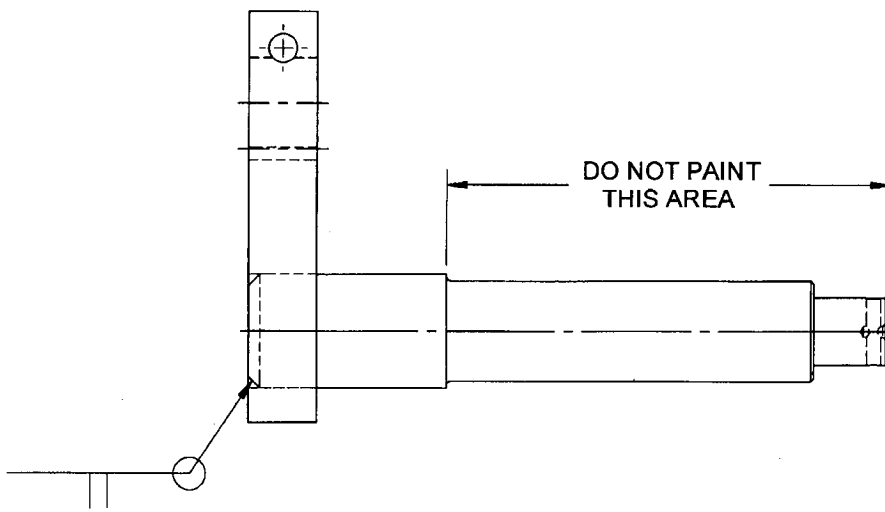
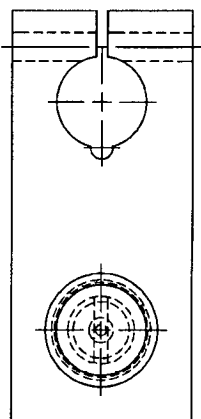
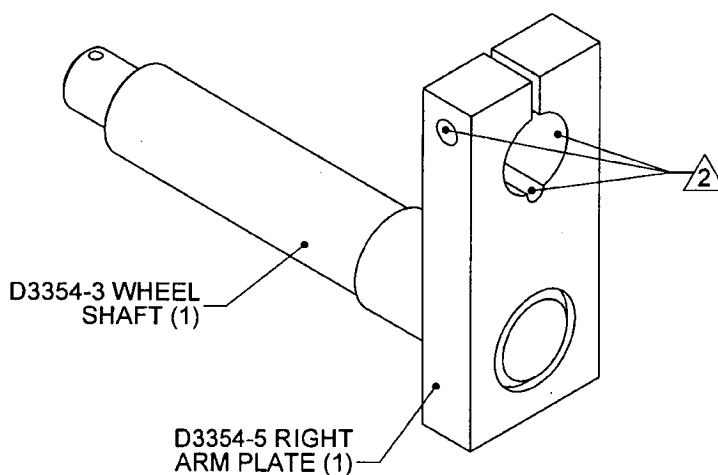
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CHECKED <i>LJ</i>	APPROVED <i>MP</i>	DRAWING NO. D3354	REV. C SHEET 2 OF 7
DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
01/12/07 *WJ*



D3354-043 RIGHT ARM WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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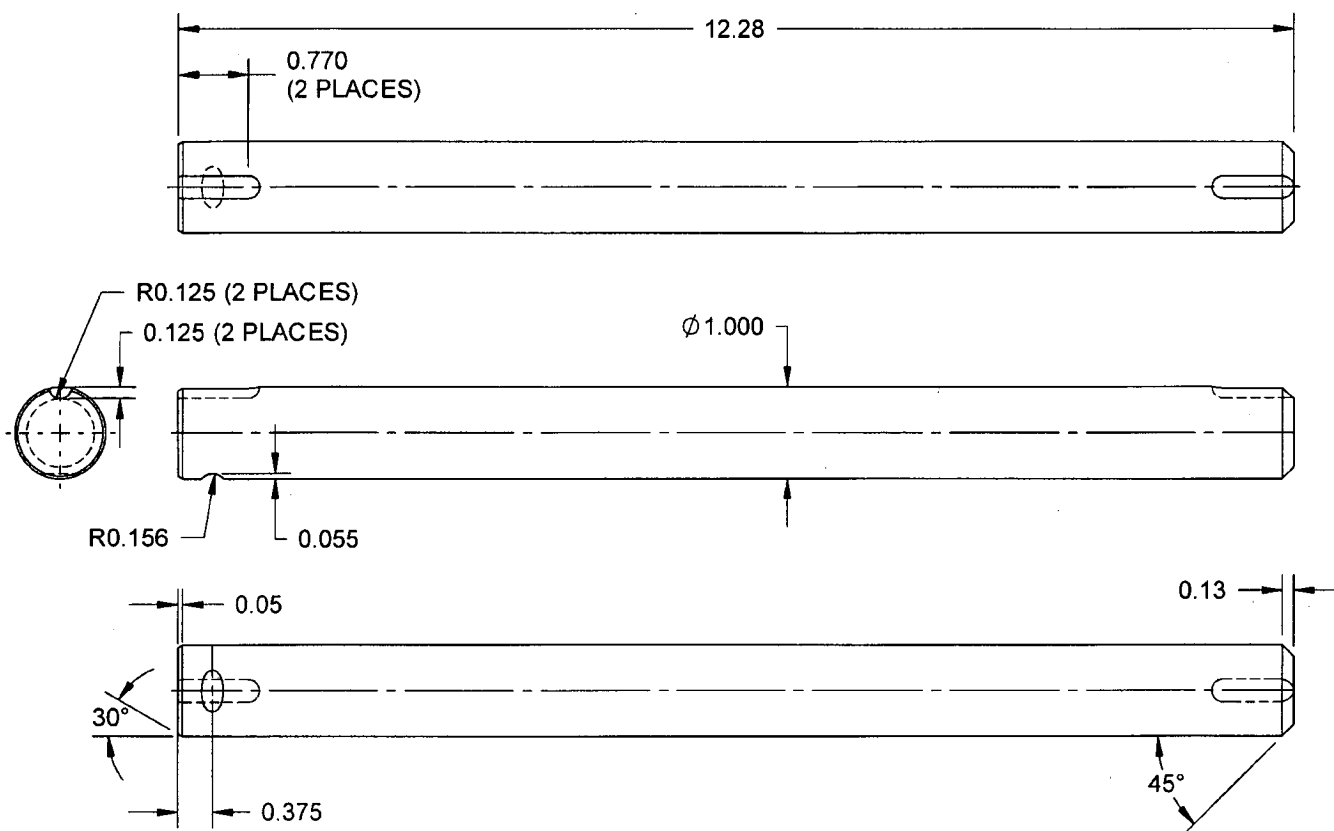
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CHECKED <i>g</i>	APPROVED <i>MP</i>	DRAWING NO. D3354	REV. C SHEET 3 OF 7
DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
01/12/07 WJ



D3354-1 INNER SHAFT

NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 RETURN TO
OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R) ENGINEERING
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED UNCONTROLLED COPY
- 3) ALL DIMENSIONS ARE IN INCHES SUBJECT TO AMENDMENT
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 WITHOUT NOTICE

WORK ORDER
NO. *42497*

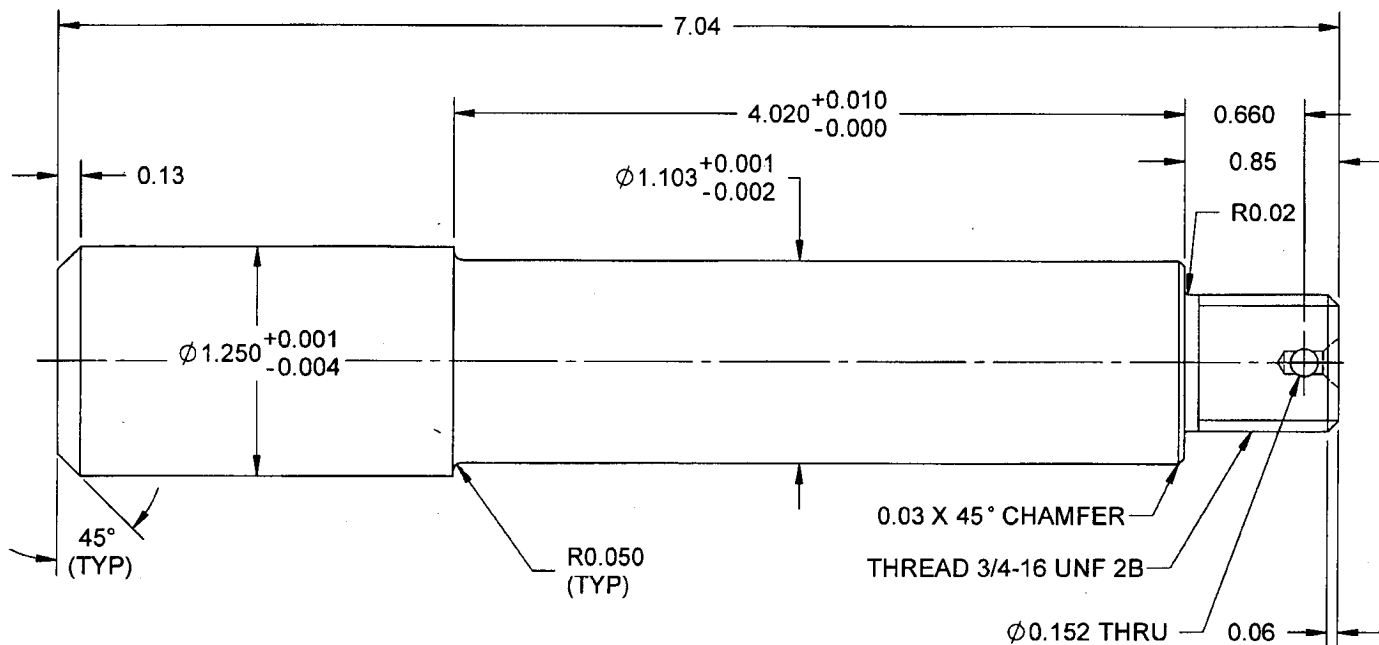
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:1

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07.12.07 *[Signature]*



D3354-3 WHEEL SHAFT

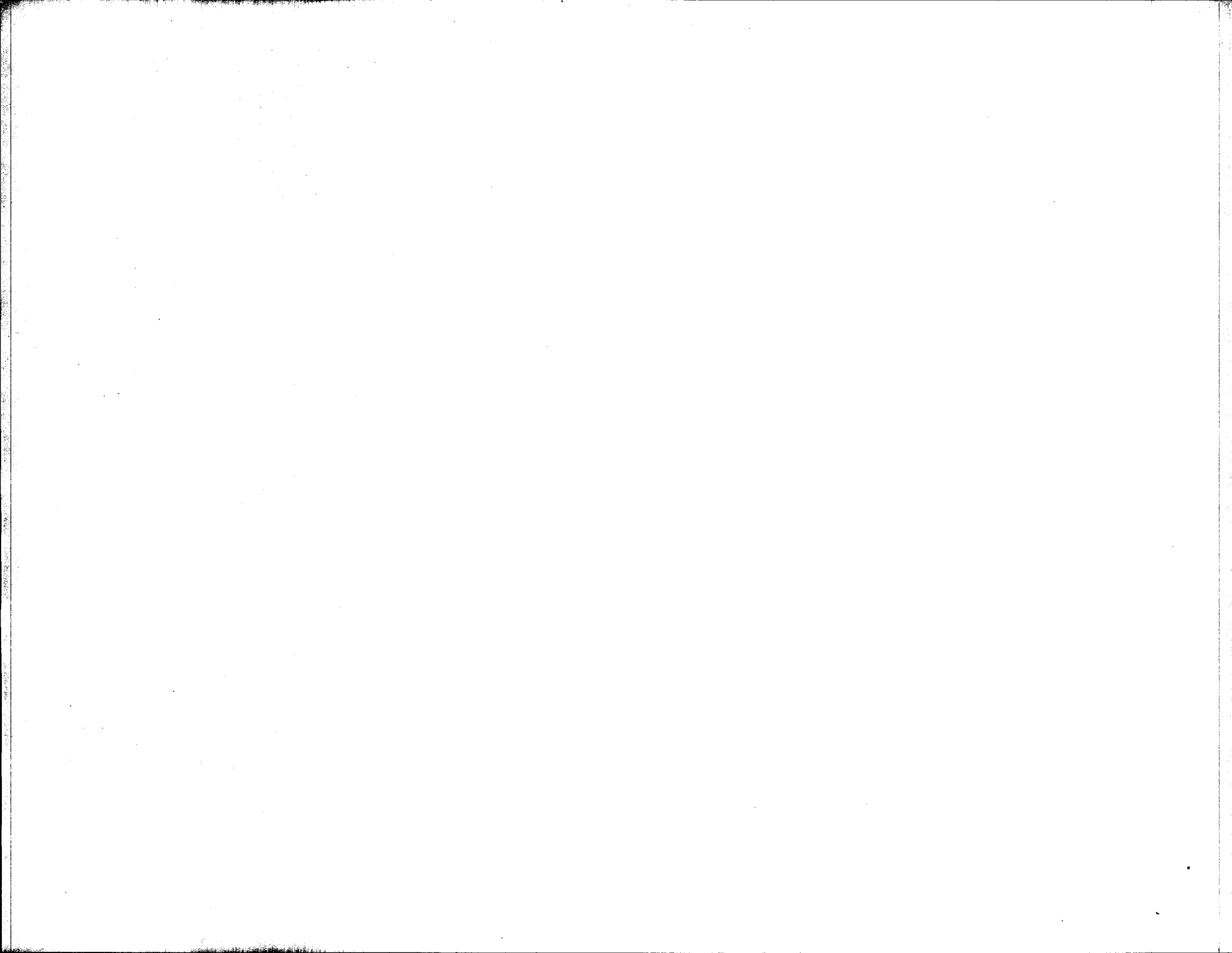
NOTES:

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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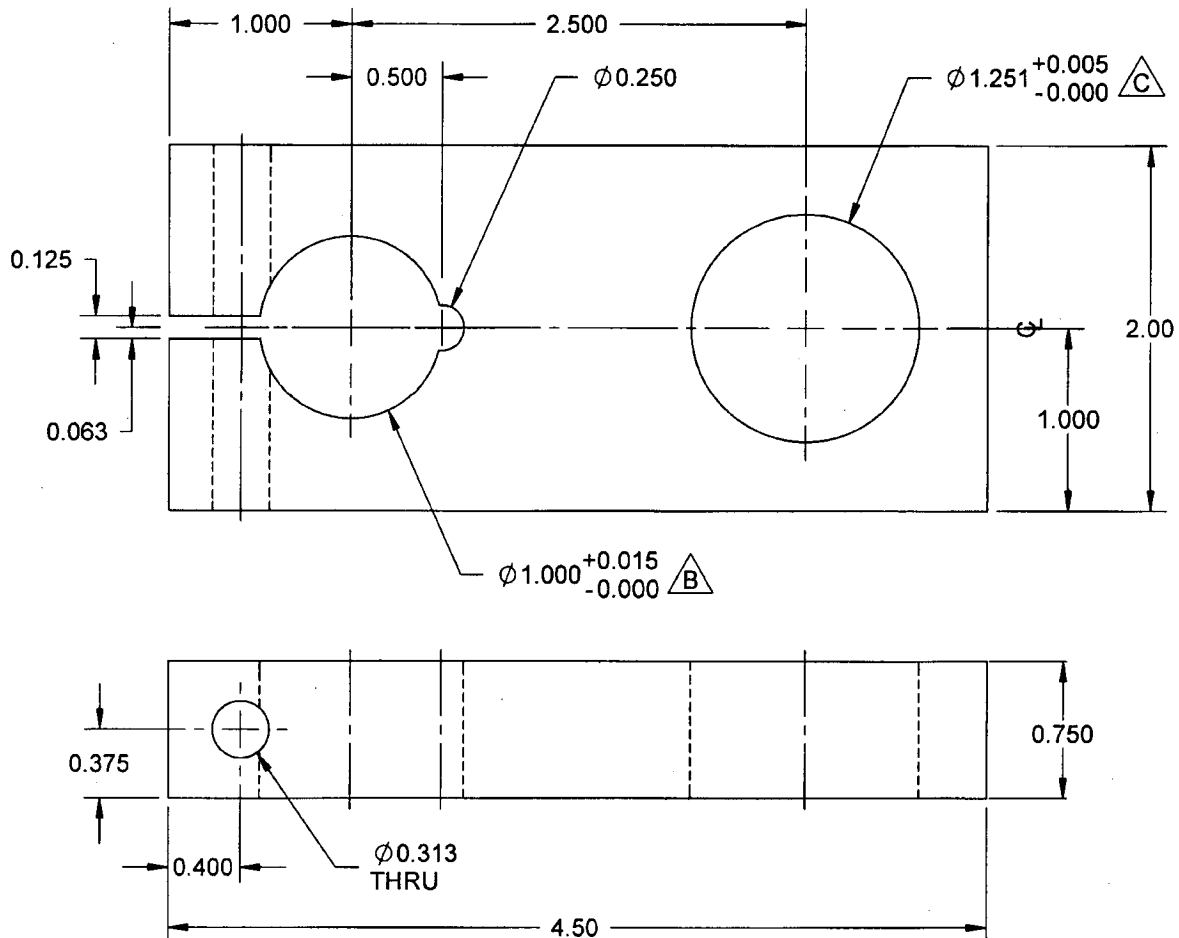
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DATE 07.12.06	TITLE LEFT ARM WELDMENT	SCALE 1:1

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07/12/07 *[Signature]*



D3354-5 RIGHT ARM PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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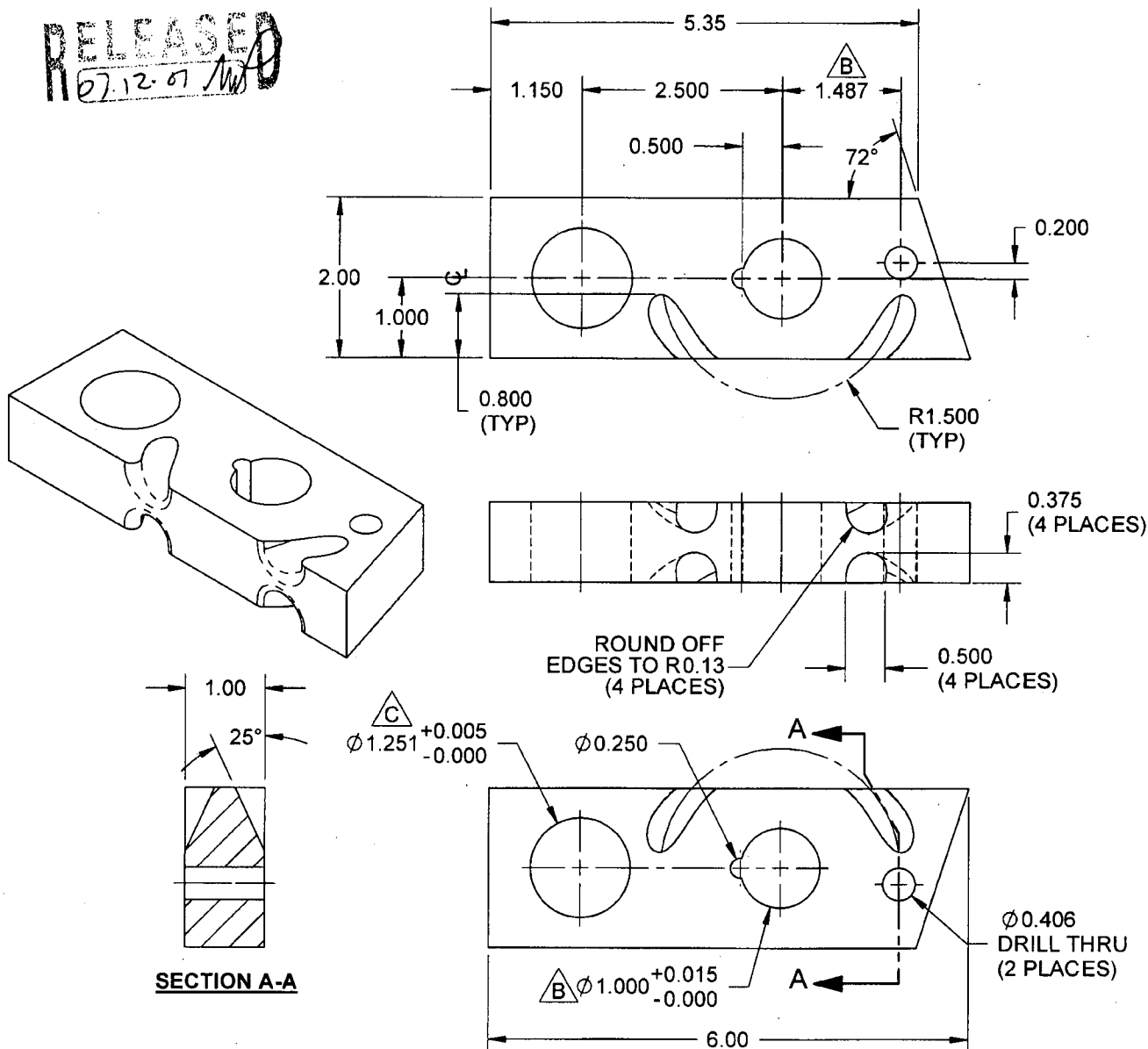
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
07.12.07 *MA*



D3354-7 LEFT ARM PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

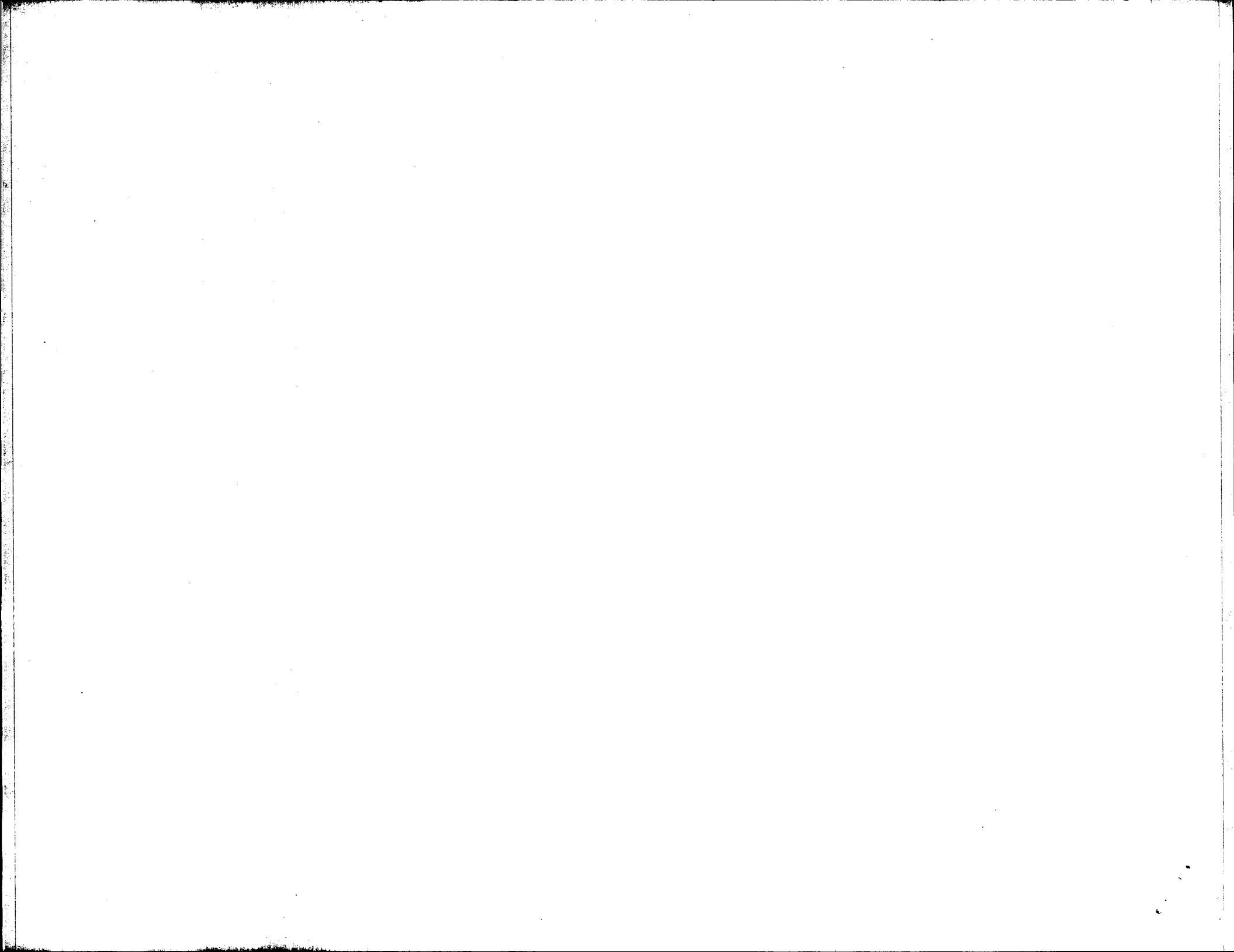
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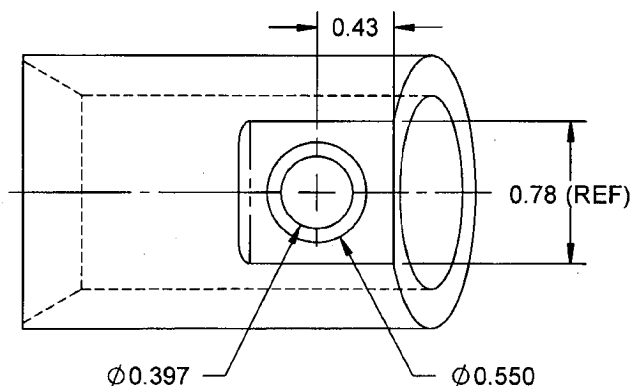
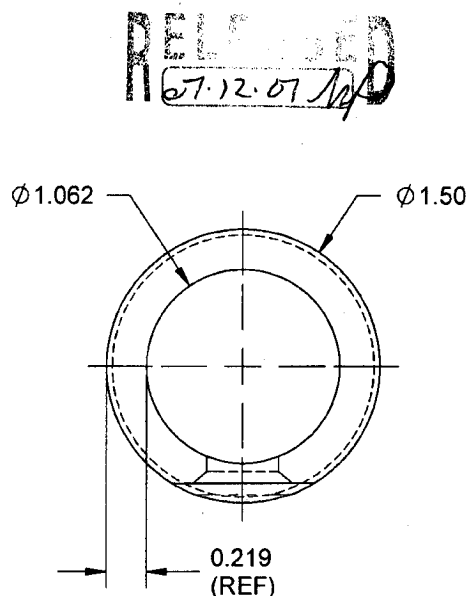
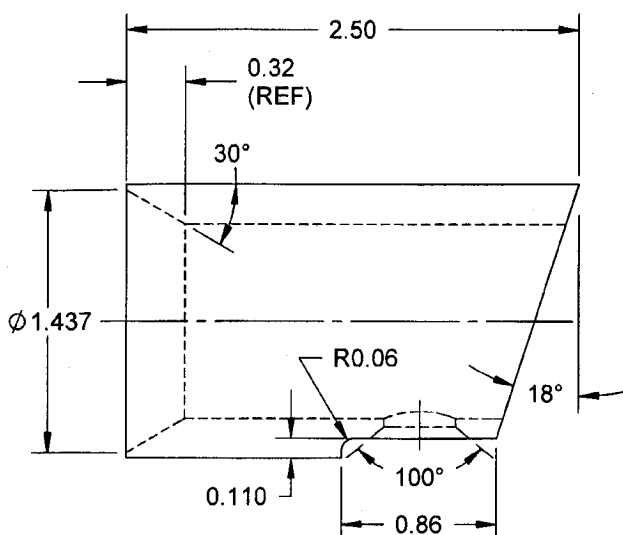
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:1



D3354-9 HANDLE SOCKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAM LESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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